

Work Order ID 144417

April 15, 2016 4:00:43 PM

144417

Page 1

Item ID: D4785-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Base Assembly, LH/RH
 Start Date: 5/30/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/17/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SEA Date: 20160415 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4785	B								

100

Weld per dwg A/R S.S. rod Batch: 4134102 0.00
 Large Fab

100

Large Fab

Large Fab

Memo

3.12

1- Use DT9610A to assemble contour ribs and the (2) D3916-5 ribs , weld as per dwg D4785

inspect before welding mesh

ENSURE BOTTOM OF BASE RIB ARE STRAIGHT

2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D4785 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends

USE DT10158 WITH SHIM WHEN WELDING BOTTOM OF RIB D4785-115

ENSURE BOTTOM OF BASE RIB ARE STRAIGHT

3- weld hinge (3) and Mounting brackets as per dwg D4785

take lid to locate hinge and bracket

4- Weld D4672-1 blanking plates as per dwg

ENSURE BOTTOM OF BASE RIB ARE STRAIGHT

①

DAS
43
9-89

MAY 24 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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110 *110* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT*** Use DT10160 jig to ensure D4785-115 holes are align after welding	0.00 0.00					① 16-05-25		DAS 9 9-89
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT*** Use DT10160 jig to ensure D4785-115 holes are align after welding ✓	0.00 0.02					① 16-05-25		DAS 9 9-89
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 1.07					1 φ 16-05-25		DAS 34 9-89

DQA: _____ Date: _____

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Work Order update only ☐

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Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat <i>M 134631</i> 1ST COAT: <u>8:05</u> START TIME: <u>8:05</u> OVEN TEMPERATURE: <u>400°</u> FINISH TIME: <u>8:35</u> ***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.66							<u>1</u> <u>φ</u> <u>16-05-26</u> <u>238</u>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01							<u>1</u>

DAS
38
9-89

MAY 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
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Page 4

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N900040100

Setup

Start

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Process Plan:

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Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Assemble as per dwg

0.00

150

HandFinish

Memo

0.41

Hand Finishing

Pick kit and assemble

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.02

Quality Control

DAS

38

9-89

MAY 27 2016

170

Identify as per dwg & Stock Location: w16

0.00

170

Packaging

Memo

0.01

Packaging

D4784-011 / B144416

1x / 16/05/26

DQA: _____ Date: _____



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180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.10

Quality Control

MC5

MAY 27 2016

MC5

MAY 27 2016

DQA: _____ Date: _____



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Page 1

Work Order ID: 144417

144417

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.14 NEW ISSUE DD VERF:JLM IPP
REV:B 13.06.17 as per dwg rev.pb1 DD VERF:JLM IPP REV:C
13.07.04 revise bom per dwg rev.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4785-1		Manufactured	No			100	Each	4.0000	2	2			
✓ *D4785-1*													
Rib													
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				4					
				133295				4					
D4785-5		Manufactured	No			100	Each	9.0000	3	3			
✓ *D4785-5*													
Rib													
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				9					
				121284				3					
				133297				6					
D4785-115		Manufactured	No			100	Each	0.0000	4	4			
✓ *D4785-115*													
Rib Assembly													
D4785-117		Manufactured	No			100	Each	0.0000	2	2			
✓ *D4785-117*													
Rib Assembly													
D4785-3		Manufactured	No			100	Each	4.0000	2	2			
✓ *D4785-3*													
Rib													
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				4					
				133300				4					

**B144940 → 2x DAS 43 MAY 19 2016 9-89

**~~B144941~~ → 3x DAS 43 MAY 19 2016 9-89
B133297 → 3x

**B146324 → 4x DAS 43 MAY 19 2016 9-89

**B146325 → 2x DAS 43 MAY 19 2016 9-89

**B144941 → 2x DAS 43 MAY 19 2016 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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OTHER : _____					

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Page 2

Work Order ID: 144417

144417

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D4017-7

Manufactured No

100 Each

9.0000

3 3

DAS

✓ *D4017-7*

Rib

**B142415 → 3x 43 MAY 19 2016
9-89

Location

Loc Qty

Loc Code

WA004

9

142415

6

143985

3

D4034-041

Manufactured No

100 Each

4.0000

1 1

DAS

✓ *D4034-041*

Aft Upper Rib Assembly

**B146167 → 1x 43 MAY 19 2016
9-89

Location

Loc Qty

Loc Code

WA004

4

141918

1

142374

3

D4034-043

Manufactured No

100 Each

4.0000

1 1

DAS

✓ *D4034-043*

Fwd Upper Rib Assembly

**B146168 → 1x 43 MAY 19 2016
9-89

Location

Loc Qty

Loc Code

WA004

4

141919

1

142375

3

D3916-5

Manufactured No

100 Each

3.0000

2 2

DAS

✓ *D3916-5*

Light Rib

**B144463 → 2x 43 MAY 19 2016
9-89

Location

Loc Qty

Loc Code

WA004

3

142370

3

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Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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Page 3

Work Order ID: 144417

144417

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D3913-1

Manufactured No

100

Each

3.0000

1 1

DAS

✓ *D3913-1*

Rib

**B144850 → 1x

43

MAY 19 2016

9-89

Location

Loc Qty

Loc Code

WA004

3

141916

3

D3913-3

Manufactured No

100

Each

3.0000

1 1

DAS

✓ *D3913-3*

Rib

**B144851 → 1x

43

MAY 19 2016

9-89

Location

Loc Qty

Loc Code

WA004

3

141917

3

D3913-9

Manufactured No

100

Each

3.0000

1 1

DAS

✓ *D3913-9*

Hinge Rib

**B144852 → 1x

43

MAY 19 2016

9-89

Location

Loc Qty

Loc Code

WA004

3

141425

3

D4793-1

Manufactured No

100

Each

3.0000

3 3

DAS

✓ *D4793-1*

Handle Plate

**B144943 → 3x

43

MAY 19 2016

9-89

Location

Loc Qty

Loc Code

WA004

3

119401

3

D4793-3

Manufactured No

100

Each

0.0000

1 1

DAS

✓ *D4793-3*

Handle Plate, Wide

**B144255 → 1x

43

MAY 19 2016

9-89

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Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Page 4

Work Order ID: 144417

144417

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D4672-1 Manufactured No

150 Each 25.0000 2 2

DAS

✓ ***D4672-1***

Blanking Plate

** B141229 → 2x

43

MAY 19 2016

9-89

Location

Loc Qty

Loc Code

WA004

25

141229

25

D4021-5 Manufactured No

100 Each 7.0000 2 2

D4021-5

Blanking Plate

** 142652

DAS

6

9-89

Location

Loc Qty

Loc Code

ST071

7

137592

6

177489bk

1

M304EX0.75-16F Purchased No

100 sf 368.0000 33 33

DAS

43

9-89

✓ ***M304EX0 75-16F***

Expanded Metal Flat SS

** 4134643 → 33x

MAY 20 2016

Location

Loc Qty

Loc Code

WA004

368

M133868

25

M134184

110

M134331

233

D4020-11 Manufactured No

100 Each 31.0000 2 2

DAS

43

9-89

✓ ***D4020-11***

End Mesh, Basket

** B142361 → 2x

MAY 20 2016

Location

Loc Qty

Loc Code

WA004

31

139947

4

142361

27

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Shop Packet Print

Page 4

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date: _____	Step #: _____	QTY Effective: _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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Picklist Print

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Page 5

Work Order ID: 144417

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D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D4016-1

Manufactured No

100

Each

33.0000

3

3

DAS

43

9-89

MAY 19 2016

D4016-1

Hinge Half, Base

**** B140745 → 3x**

Location

Loc Qty

Loc Code

WA004

33

140745

33

D2931

Manufactured No

150

Each

1,599.000

2

2

DAS

6

9-89

MAY 26 2016

D2931

Bumper

Location

Loc Qty

Loc Code

ST013

76

86435

76

ST025A

1523

86435

1523

D2581

Manufactured No

100

Each

82.0000

2

2

DAS

43

9-89

MAY 19 2016

D2581

Mounting Bracket

**** B142787 → 2x**

Location

Loc Qty

Loc Code

WA004

82

132771

1

136270

2

139082

11

141097

20

142787

48

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Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Page 6

Work Order ID: 144417

144417

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-10A

Purchased

No

150

Each

269.0000

6

6

AN3-10A

Bolt

DAS

6

~~9.09~~

Location

Loc Qty

Loc Code

GA

1

m132763

1

over003

100

m134249

100

ST349

168

m133992

68

m134573

100

MS20600-AD4W3

Purchased

No

150

Each

430.0000

2

2

MS20600-AD4W3

Cherry Rivets

DAS

6

~~9.09~~

Location

Loc Qty

Loc Code

GA

160

m129795

160

ST308

186

m133316

24

m134167

162

WA003

84

m130018

84

MAY 26 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER : ☐																																																																					

Picklist Print

April 15, 2016 4:00:42 PM

Page 7

Work Order ID: 144417

144417

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,784.000

6

6

MS21042L3

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

786

m133790

3

m134360

783

ST304

898

m134039

12

m134360

886

NAS1149DN832J

Purchased

No

150

Each

1,801.000

2

2

NAS1149DN832J

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST265

1717

M131697

220

M134180

1497

NAS1149F0332P

Purchased

No

150

Each

1,915.000

12

12

NAS1149F0332P

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

312

m133709

312

ST262

1603

m134134

103

m134257

1500

MAY 26 2016

April 15, 2016 4:00:42 PM

Shop Packet Print

Page 7

DQA: _____ Date: _____



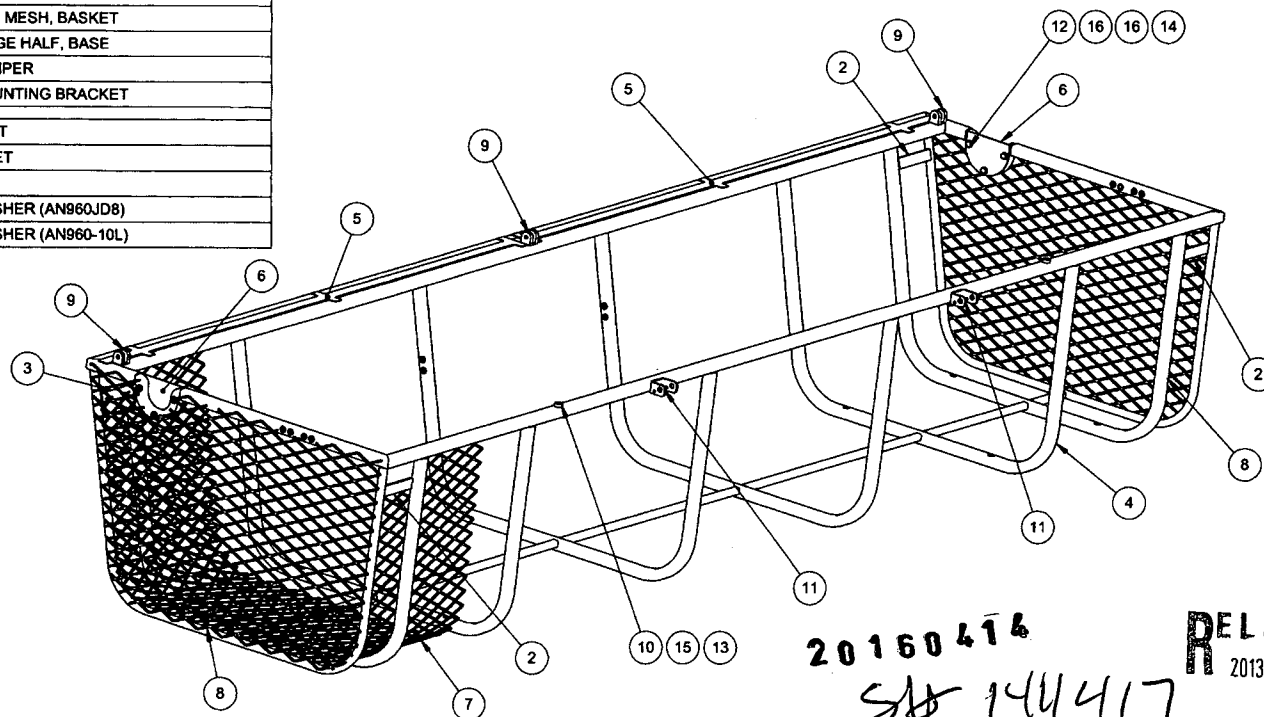
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4785-041	LONG BASKET BASE ASSY, LH/RH
2	3	D4793-1	HANDLE PLATE
3	1	D4793-3	WIDE HANDLE PLATE
4	1	D4785-101	TUBULAR ASSEMBLY, LH/RH
5	2	D4672-1	BLANKING PLATE
6	2	D4021-5	BLANKING PLATE
7	1	D4020-1	MESH BASKET LONG, BASE
8	2	D4020-11	END MESH, BASKET
9	3	D4016-1	HINGE HALF, BASE
10	2	D2931	BUMPER
11	2	D2581	MOUNTING BRACKET
12	6	AN3-10A	BOLT
13	2	MS20600AD4W3	RIVET
14	6	MS21042L3	NUT
15	2	NAS1149DN832J	WASHER (AN960JD8)
16	12	NAS1149F0332P	WASHER (AN960-10L)



D4785-041 LONG BASKET BASE ASSY, LH/RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 50.42 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

20160414

SH 144417

RELEASED
2013-06-20

B	REPLACE D3916-5 WITH D4785-117 (ZN B5-4, B4-4, B5-7); REVISE D4785-5 DIMENSION (ZN B5-5)	RF	13.06.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	JS	D4785	SHEET 1 OF 7
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	LONG BASKET BASE ASSY	NTS
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

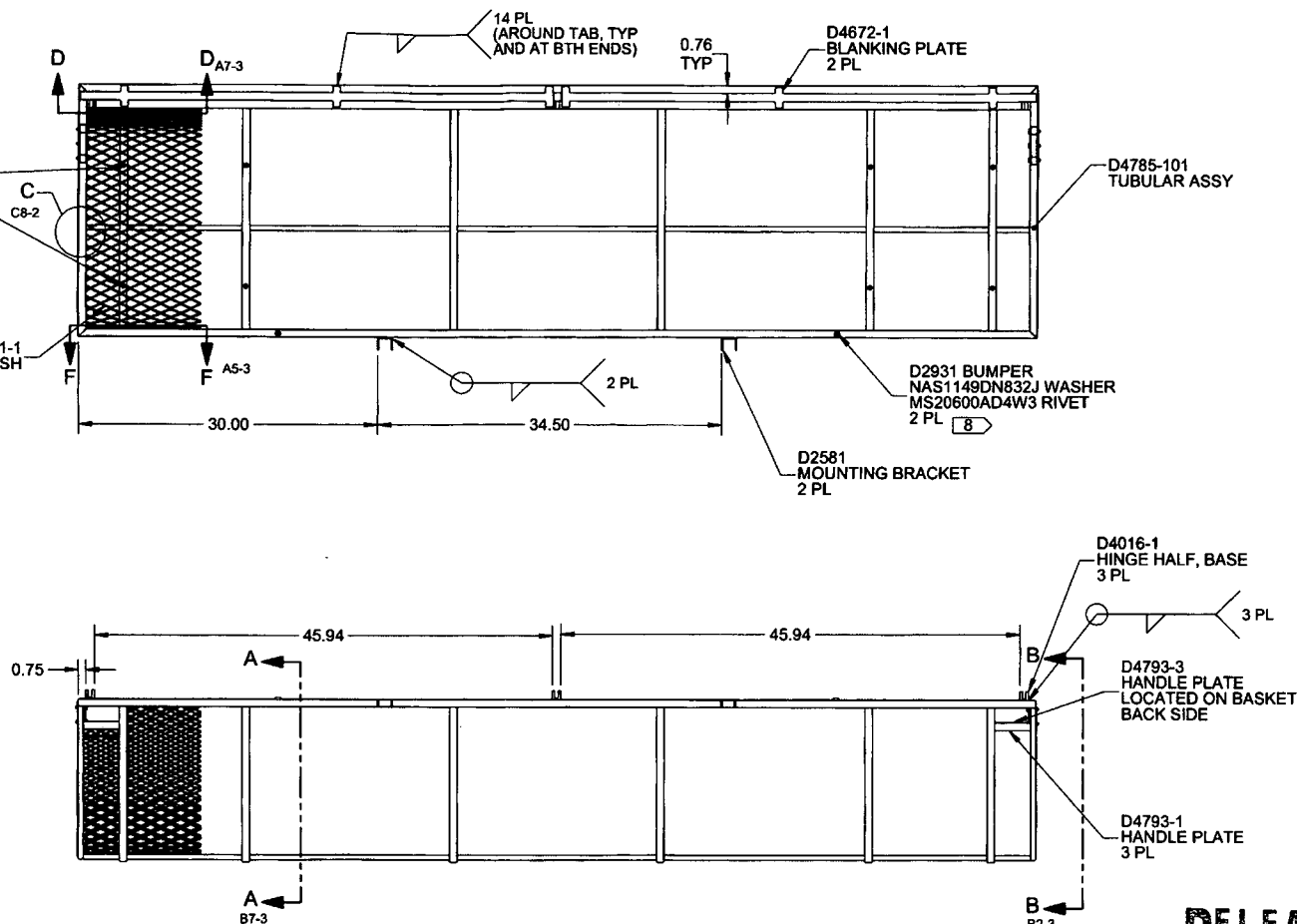
TRIM MESH LOCALLY
Ø0.50 - Ø0.60
TO CLEAR BUSHINGS
TYP

D4021-1
MESH



TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

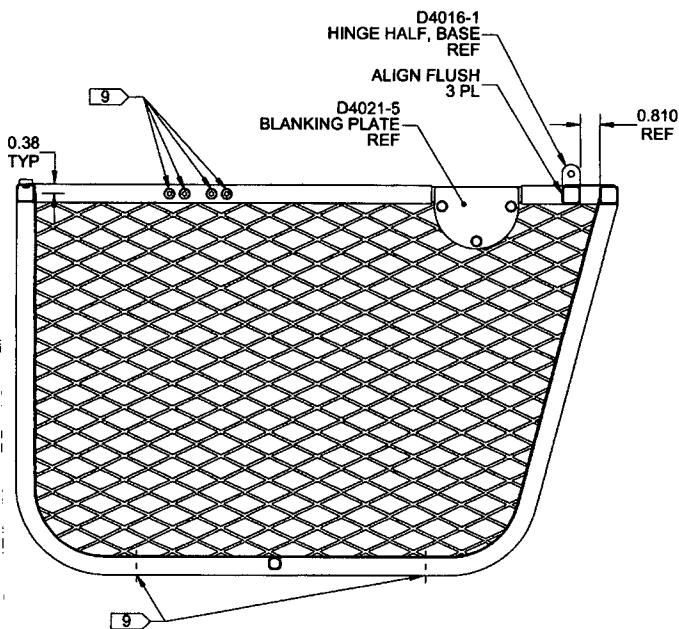
DETAIL C D7-2



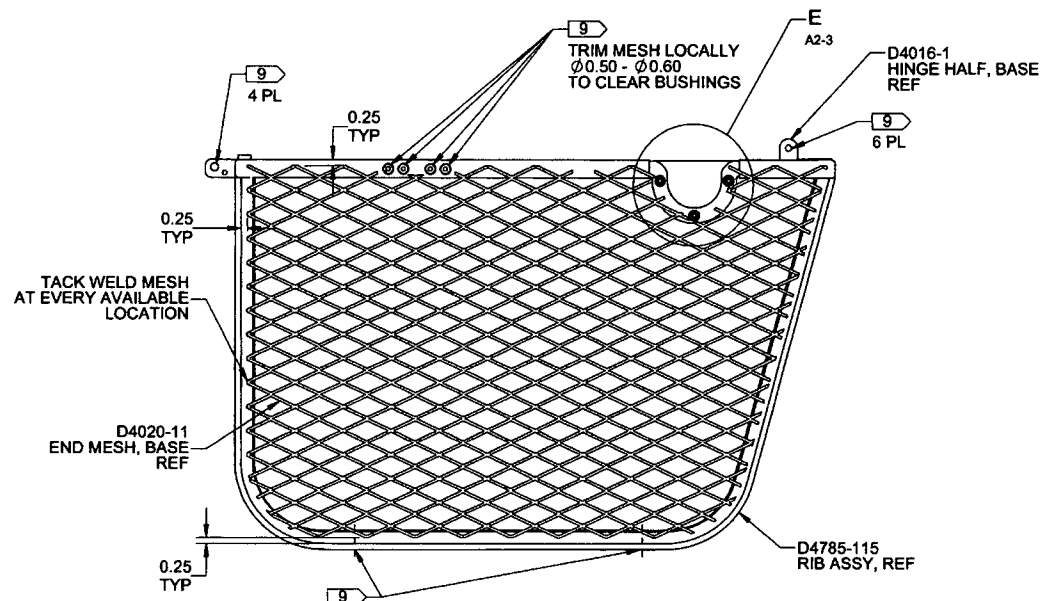
D4785-041 LONG BASKET BASE ASSY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2013-06-20

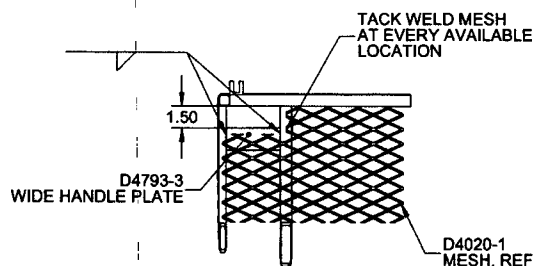
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DRAWN	RF		
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	N	D4785	SHEET 2 OF 7
APPROVED	#	TITLE	SCALE
DE APPR.	#	LONG BASKET BASE ASSY	NTS
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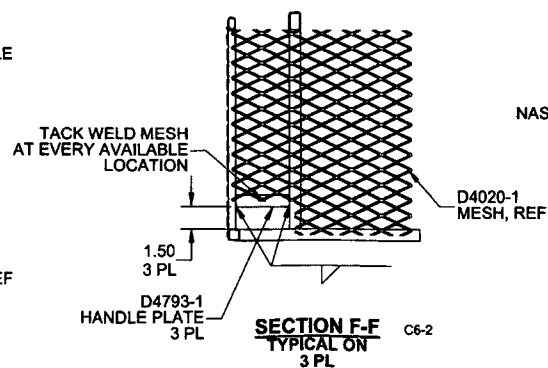
SECTION A-A B7-2



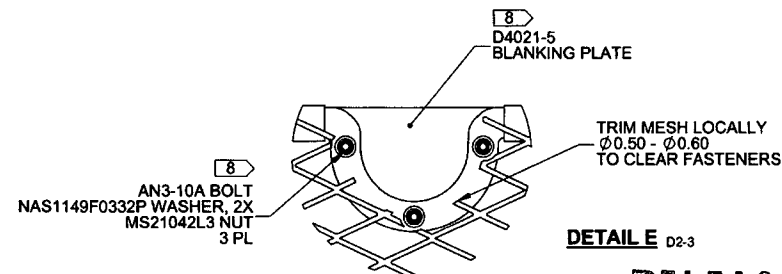
SECTION VIEW B-B A2-2



SECTION D-D D6-2



SECTION F-F C6-2
TYPICAL ON 3 PL



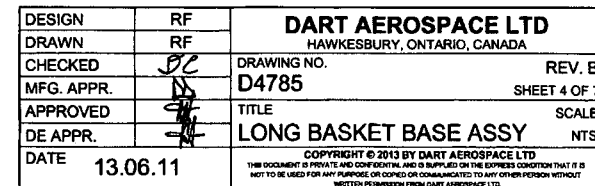
DETAIL E D2-3

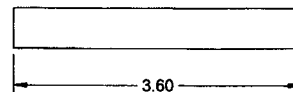
RELEASED
R 2013-06-20
AND

DESIGN	RF	715 DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	OC	DRAWING NO.	REV. B
MFG. APPR.	JS	D4785	SHEET 3 OF 7
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	LONG BASKET BASE ASSY	
DATE	13.06.11	NTS	
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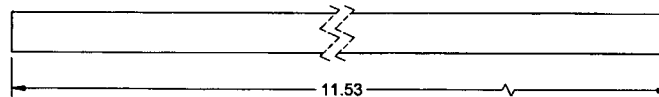
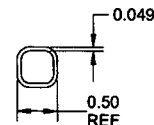
D4785-101 TUBULAR ASSEMBLY, LH/RH

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 28.65 lbs
 8) WELD PER DART QSI 004

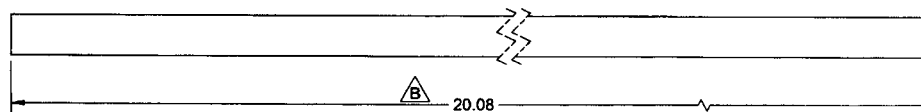
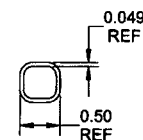




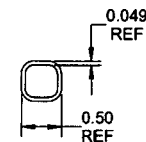
D4785-1 RIB



D4785-3 RIB



D4785-5 RIB



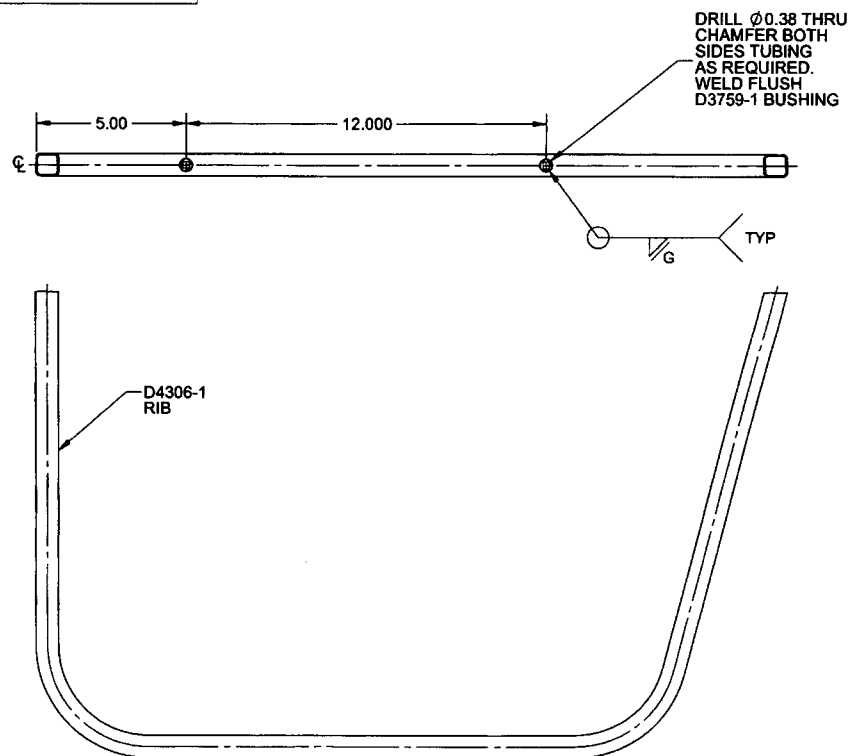
NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
2013-06-20
mt

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>PC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JS</i>	D4785	SHEET 5 OF 7
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	LONG BASKET BASE ASSY	NTS
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM NO.	QTY. -115	PART NUMBER	DESCRIPTION
1	X	D4785-115	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D3759-1	BUSHING



D4785-115 RIB ASSEMBLY
MAKE FROM D4306-1 RIB

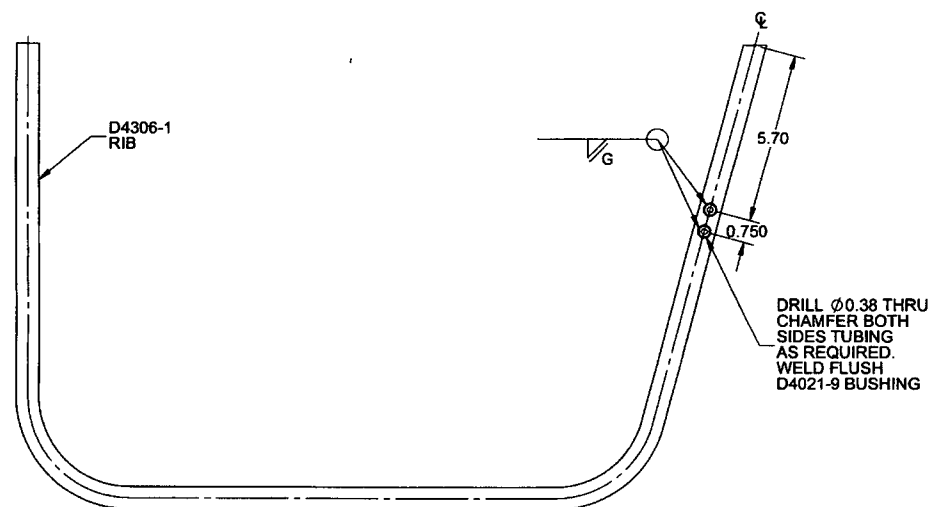
RELEASED
2013-06-20
JND

NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.80 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	NS	D4785	SHEET 6 OF 7
APPROVED	NS	TITLE	SCALE
DE APPR.	NS	LONG BASKET BASE ASSY	NTS
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ITEM NO.	QTY. -117	PART NUMBER	DESCRIPTION
1	X	D4785-117	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D4021-9	BUSHING



D4785-117 RIB ASSEMBLY 
MAKE FROM D4306-1 RIB

NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs
- 8) WELD PER DART QSI 004

RELEASED
2013-06-20

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4785	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
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